Work Order ID 70820 / Wednesday, June 15, 2011 2:27:53 PM



Page 1

Wednesday, June	2 15, 2011 2:27:53 PM	H)HI	<u> </u>								
Revision ID:	D3405-041		A	ccept				s	etup Stari		
•	Lug Assembly 6/15/2011				Cust Item Customer						
Approvals:	Process Plan:QC:	Date:		Tooling: SPC (Y/N):		Date:		R	tun Star Stop		
Sequence ID/ Work Center II				Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3405	Revision Nbr Rev B							÷			
100 Waterjet FLOW CNC Waterje	et 1	Memo 1-Cut as per Dwg D3405		0.00				1811-	6-16		
364.175	I	Dwg Rev: Prog Rev: 2-Deburr if necessary	-		. 7	**************************************				()	8)
110		t parts off machine FAI/I	FAIB	0.00				<u> 1311</u>	-6-16		·
QC Quality Control	ĭ	Memo		0.00							
120	QC8- Inspect	t parts - second check		0.00	. 1) ,		
QC Quality Control	1	Memo		0.00 & W	4/16			40)		

	Jopass								
W/O:			W	ORK ORDER CHANGE	ES				3
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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·									
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date:	
		esolution:							
NCR:			WORK ORE	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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Work	: ()	rder	ID	70820
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Page 2

Item ID:

Wednesday, June 15, 2011 2:27:53 PM

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Lug Assembly

6/15/2011

D3405-041

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Required Date: 6/22/2011

QC:

Date:

SPC (Y/N):

Tool ID

Date:

Tool # Plan

Code

Stop

Reject

Qty

Reject

Number

Insp.

Stamp

Sequence ID/ **Work Center ID**

130

Brake NC

Brake NC

Operation Description

NC BRAKE

Set Up/ **Run Hours**

0.00

0.00

Memo 1-Deburr

2-Form using DT8204 as per Dwg D3405

Su 11/06/17

3- use DT9681 to check if correct forming

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Accept

Qty

150

Large Fab

Large Fab

Large Fab

Memo

Memo

Weld as per Dwg D3405 use DT8484

Identify as D3405-041

0.00 0.00

A 47-4



W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PROC	EDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									
							<u>.</u>		
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A :	_ Date: _	
	Re	esolution:	Disposition	on:	QA: N/C C	losed:		Date: _	
NCR:		W	ORK ORD	ER NON-CONFORMAN	NCE (NC	₹)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti		Chief Eng	QC Inspector
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Work Order ID 70820

Wednesday, June 15, 2011 2:27:53 PM



Page 3

Item ID:

D3405-041

Accept

Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Lug Assembly

6/15/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date:

Tooling:

Date:

Start



Required Date: 6/22/2011

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

160

OC

Quality Control

Operation Description

QC9- Inspect visual per QSI004- Fusion Welds

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Run

Reject Number Stamp

Insp.

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

180

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powder Coating

Memo

START TIME: OVEN TEMPERATURE:

FINISH TIME:

W/O:			M	ORK ORDER CHANGE	S				
DATE	STEP	PROG	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DO)A:	Date:	
	R	esolution:	Disposit	ion:	QA: N/C	Closed: _		Date: _	
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verif	ication	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	l&k Sec	tion C	Chief Eng	QC Inspector
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Work Order ID 70820

Page 4

Wednesday, June 15, 2011 2:27:53 PM

Item ID:

D3405-041

Accept

Setup Start



Stop

Revision ID:

Item Name: **Start Date:**

Lug Assembly

6/15/2011

QC:

Start Qty: 12.00

Reg'd Oty: 12.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

Date:

Date:

Run

Start

Stop

Sequence ID/ **Work Center ID**

Required Date: 6/22/2011

190

QC

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Run Hours

0.00

SPC (Y/N):

Set Up/

0.00

Tool # Plan Code

Accept Qty

Reject Oty

Reject Number Stamp

Insp.

Bl 11-7-7.

200

Packaging Packaging

Identify as per dwg & Stock Location:

Memo

0.00

210

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF 17-07

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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							To the state of th			
Part No	•	PAR #:	Fault Cat	tegory:	_ NCR	: Yes N	lo DQA	۸:	Date:	
	R	esolution:	Disposit	ion:	_ QA:	N/C Clo	sed:		Date: _	
NCR:	,	V	WORK ORI	DER NON-CONFORMA	ANCE	(NCR)				
DATE	STEP	Description of NC		Corrective Action Section	ion B		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
								-		

Picklist Print

Wednesday, June 15, 2011 2:28:00 PM

Work Order ID: 70820

Parent Item:

D3405-041

Parent Item Name: Lug Assembly



Start Date: 6/15/2011

Required Date: 6/22/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP A□05.09.01□New issue□KJ/JLM□

IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	_
D3404-1		Manufactured	No			100	Each	35.0000	1 	12 A	11-7	-4		_
				Location	<u>1</u>	Loc	<u>Oty</u>	Loc Code						
				WA			32			,				Y^1
					69883		32			8	- -		·	-
				WA030			3		<u></u>		_			
					67127		3		_		_			
M304S11GA		Purchased	No			150	sf	127.0000		1.945263	3			
304/316 0.125 Sheet										<u></u>	611-6-16)		
				Location	<u>1</u>	Loc	<u>Oty</u>	Loc Code				_		
				MAT020)		127					(1	77	
				•	117494		127			17444	- -	0	ン	

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	R	esolution:	Disposit	ion:	_ QA: N/C	Closed	i :	Date: _	
NCR:		· V	VORK OR	DER NON-CONFORMA	ANCE (NO	CR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	ion B Sig Da	n &	/erification Section C	Approval Chief Eng	Approval QC Inspector
			Officer Eng	Office Eng					
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									<u> </u>

DART AEROSPACE LTD	Work Order:	70820
Description: GHW Lug	Part Number:	D3405-1
Inspection Dwg: D3405 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	 -	First	_	 1		
		First Art	icle	Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.438	+0.006/-0.001	,441	>		V BOL	
1.50	+/-0.030	1.500	ठ		ν	
1.750	+/-0.010	1.751	~		V	
6.751	+/-0.010	6.752	×		V	
8.00	+/-0.030	8.001	*		V	
0.125	+/-0.010	117	>		V	
				,		
	- i i					
						
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Measured by:	Audited by:	Prototype Approval:	N/A
Date: 11-6-16	Date: 4/06/16	Date:	N/A

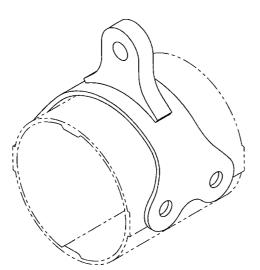
Rev	Date	Change	Revised by	Approved
Α	08.11.28	New Issue P/O D3405-041	KJ/EC	71
В	09.05.04	Dimensions update per Dwg Rev. B	KJ/DD 👯	
_ ט	09.03.04	Difficilisions appeare per Birg (181)		

W/O:			WC	RK ORDER CHANG	ES						
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
				TARRAN MARKANINA MAR			<u></u>				
Part No: PAR		PAR #:	Fault Category: NC			NCR: Yes No DQA: Date:					
Resolution:			Disposition: Q			QA: N/C Closed: Date:					
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NC	₹)					
DATE	STEP	Description of NC	Corrective Action Section B				cation		Approval		
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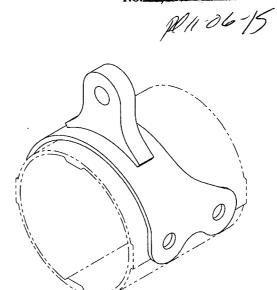
[·] H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

B

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		Х	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET



D3405-041 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)



SHOP COPY RETURN TO **ENGINEERING**

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 70820

D3405-043 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)



NOTES: 1) MATERIAL: N/A 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: -041, 0.85 lbs -043, 0.87 lbs

: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER

DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 8-3 INCRESSED IN LENGTH TO PREVENT FOULING AT INST. (SEE PAR198). SHEETS 3 & 4 ZONE & 6 1.20 DIM WAS 4.100. AJS 08.09.19 Α NEW ISSUE PH 05.03.08 REV. DESCRIPTION DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3405 MFG. APPR. SHEET 1 OF 4 APPROVED GHW LUG ASSEMBLY DE APPR NTS DATE 08.09.19

COPYRIGHT © 2005 BY DART AEROSPACE LTD

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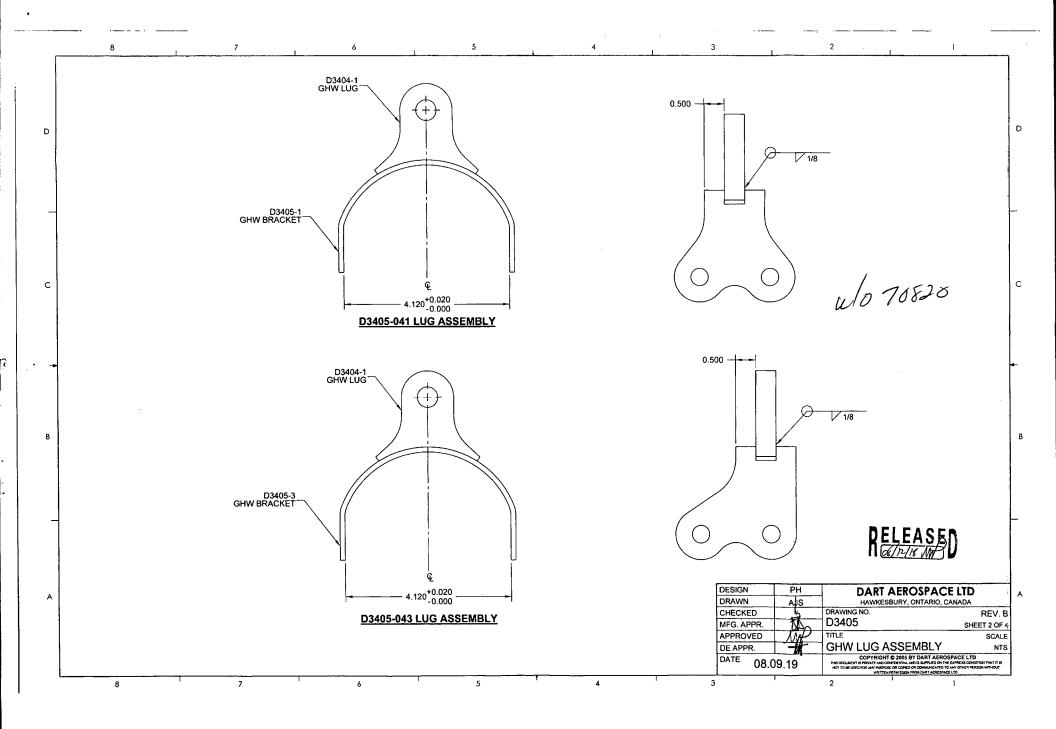
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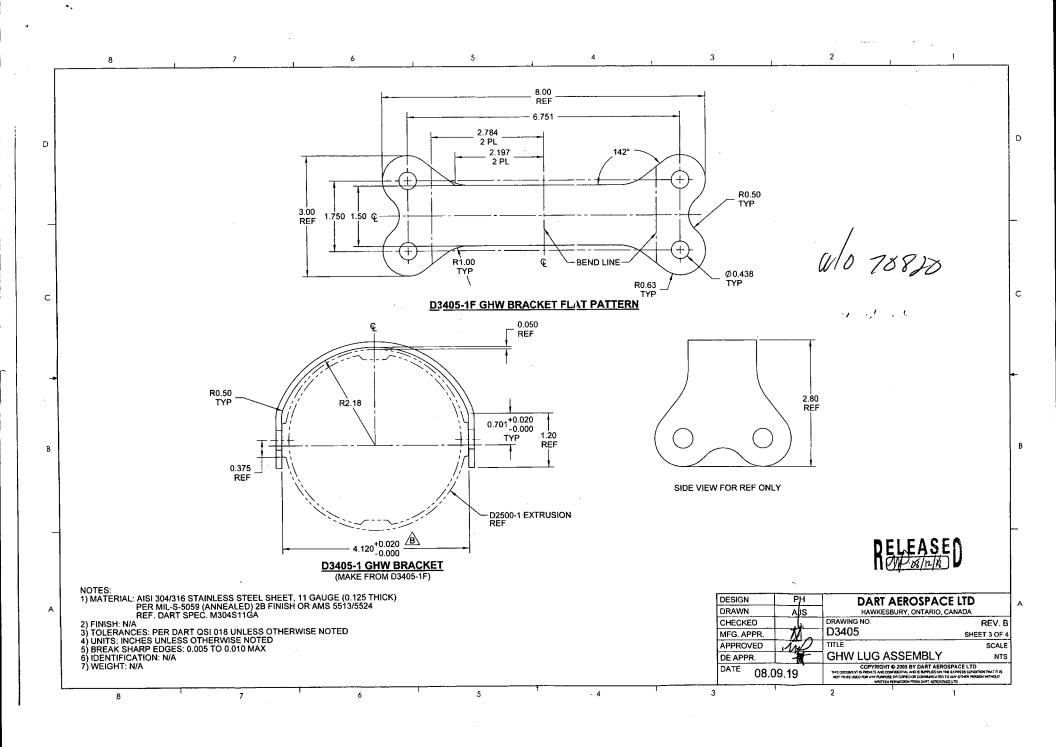
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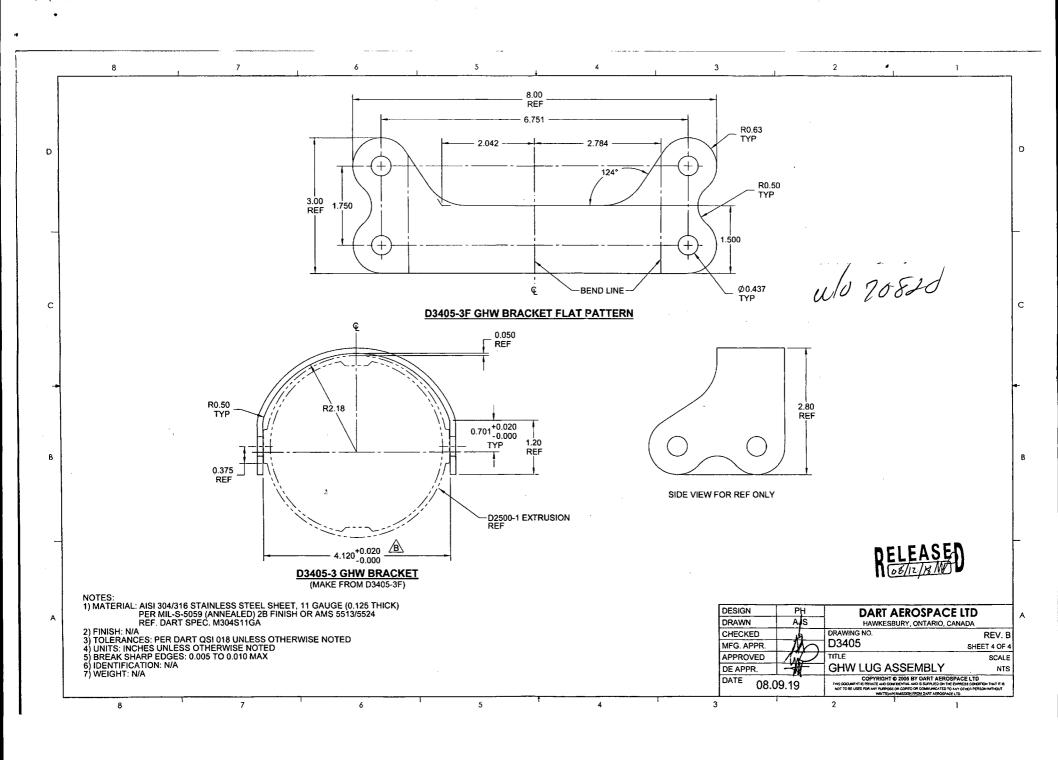
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Resolution:		Disposition	QA: N/C C	QA: N/C Closed: Date:					
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DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descript		on B	Secti	cation ion C	Approval Chief Eng	Approval QC inspector
			Chief Eng	Chief Eng	Date				



Dart Aerosi	pace Ltd
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W/O:			WO	RK ORDER CHANG	ES						
DATE STEP		PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Resolution:		olution:	Disposition	sed:	sed: Date:						
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCR)					
DATE	STEP	Description of NC			Section B		cation	Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector		
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